

Date: Thursday, 2/14/2008 11:01:28 AM  
User: Kim Johnston

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG BRACKET
Job Number	: 37439		
Estimate Number	: 10010		
P.O. Number	:	Part Number	: D27353
This Issue	: 2/14/2008 S.O. No. :	Drawing Number	: D2735 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C ✓
Previous Run	: 35434	Material	:
Written By	:	Due Date	: 3/10/2008 Qty: 12 Um: Each
Checked & Approved By	: <u>08 02 14</u>		
Comment	: Est Rev: C Removed from 9 Digit 05-10-25 JLM		
	: Est. C 06.07.21 waterjet EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S125	1010-1025 sheet .125
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Comment: Qty.: 0.1733 sf(s)/Unit Total : 2.0790 sf(s)  
1010-1025 sheet .125  
batch: 106140 HB 8-2-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
1-Cut as per Dwg D2735  
Dwg Rev: C HB 8-2-21  
Prog Rev: C  
  
2-Deburr if necessary HB 8-2-21



3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

02-25 15  
checked.

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE  
1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204  
  
2-Deburr if required.

SB 08/03/12



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: ND Date: 08/03/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG BRACKET

Job Number: 37439

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/12 (15)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: Steve

08/3/13 (15)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/14

Job Completion



08/03/13 (15)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

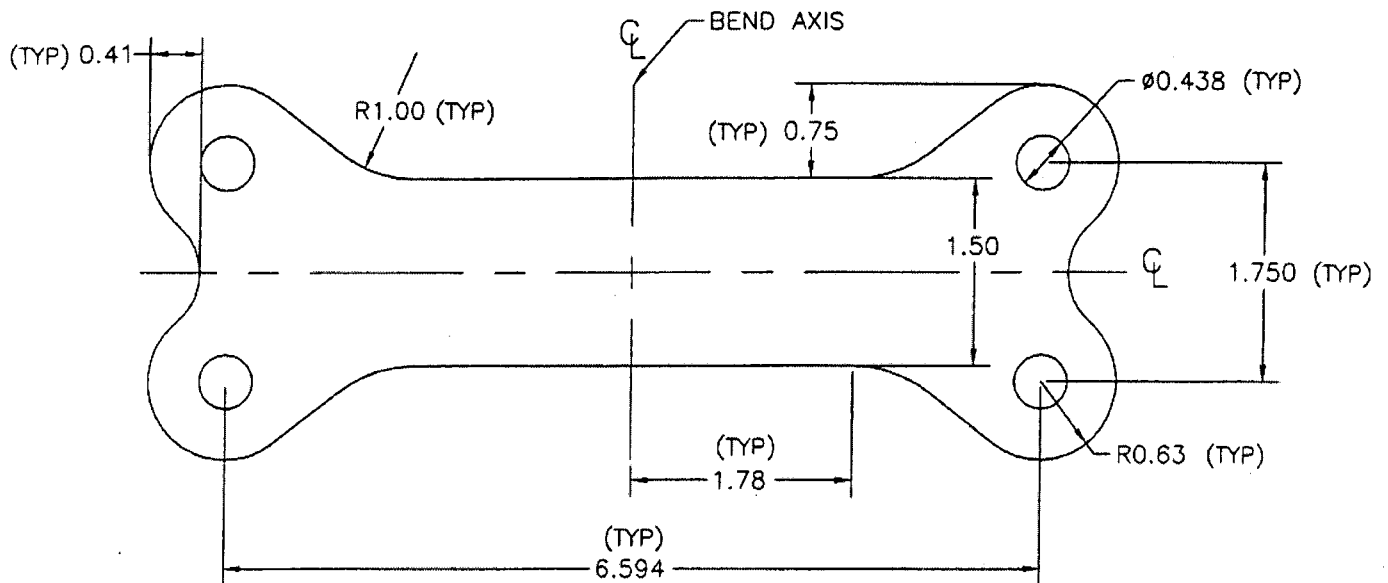
**NOTE:** Date & initial all entries



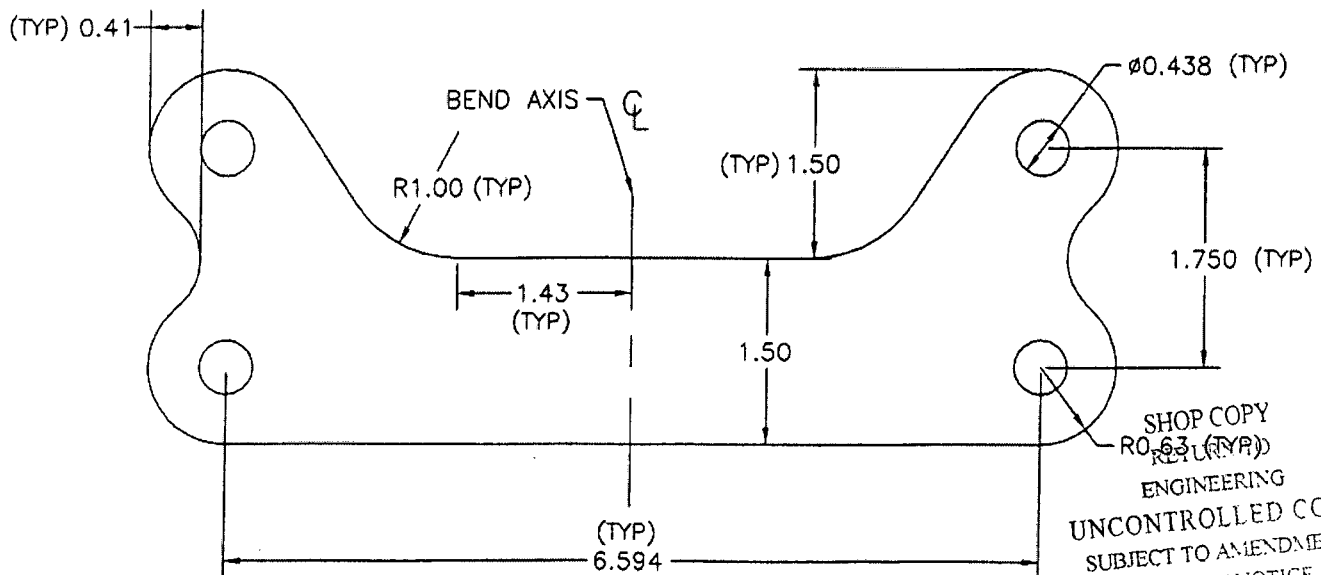


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED  
98.12.14 DS



D2735-1 FLAT PATTERN  
SYMMETRIC ABOUT BOTH CENTRE-LINES ( $\phi$ )



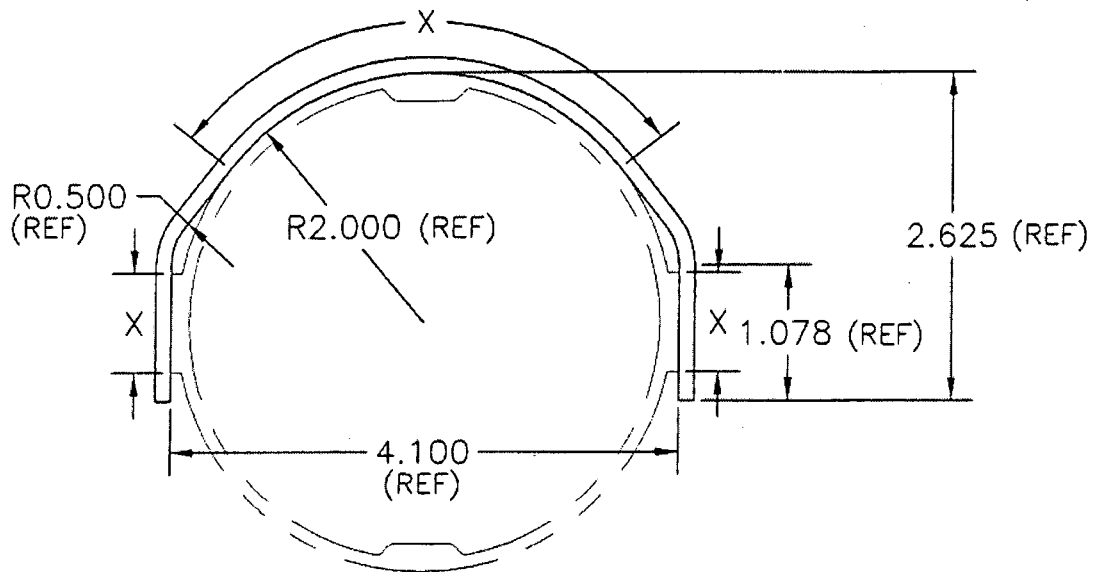
D2735-3 FLAT PATTERN  
SYMMETRIC ABOUT CENTRE-LINE ( $\phi$ )

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WITHOUT NOTICE  
WORK ORDER  
NO. 37439



DESIGN <i>AT</i>	DRAWN BY <i>AT</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED  
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.125 THICK (11 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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